

Tuesday, 01/05/2007 2:27:00 PM  
Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 31864 - 2

Estimate Number : 12752

P.O. Number : N/A

This Issue : 01/05/2007

Prsht Rev. : NC

First Issue : N/A

Previous Run : 32126

Written By : Checked & Approved By : 

Comment : Est Rev:A New Issue 07-01-29 JLM

Drawing Name : ADAPTER

SPLIT

Part Number : D35737

Drawing Number : D3573 REV.A

Project Number : N/A

Drawing Revision : A

Material : N/A

Due Date : 13/05/2007

Qty: 42 Um: Each

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B0500X02500

6061-T6 Bar .50" x 2.5"

Comment: Qty.: 0.3066 f(s)/Unit Total: 18.3960 f(s) M18530 → 8 pieces

\* 6061-T6 Bar .50" x 2.5"

Batch: M103435 → 37 pieces

ml 07/05/09 (18) 45

2.0

BAND SAW

BAND SAW

Comment: BAND SAW

3.500

Cut blank - 2.250" long

ml 07/05/09 (18) 45

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA677 and Dwg D3573

ml 07.05.11 (18) 45

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07.05.11 (18) 45

5.0

QC8

SECOND CHECK

Comment: SECOND CHECK

J.L 07/05/14

ml 07/05/09 (18) 45

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

\* HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fd 07/05/14 (45)



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 31864

Part Number: D35737

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601 HJ 07-05-15

45

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/16 45

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/05/16 45

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/16

43

Job Completion



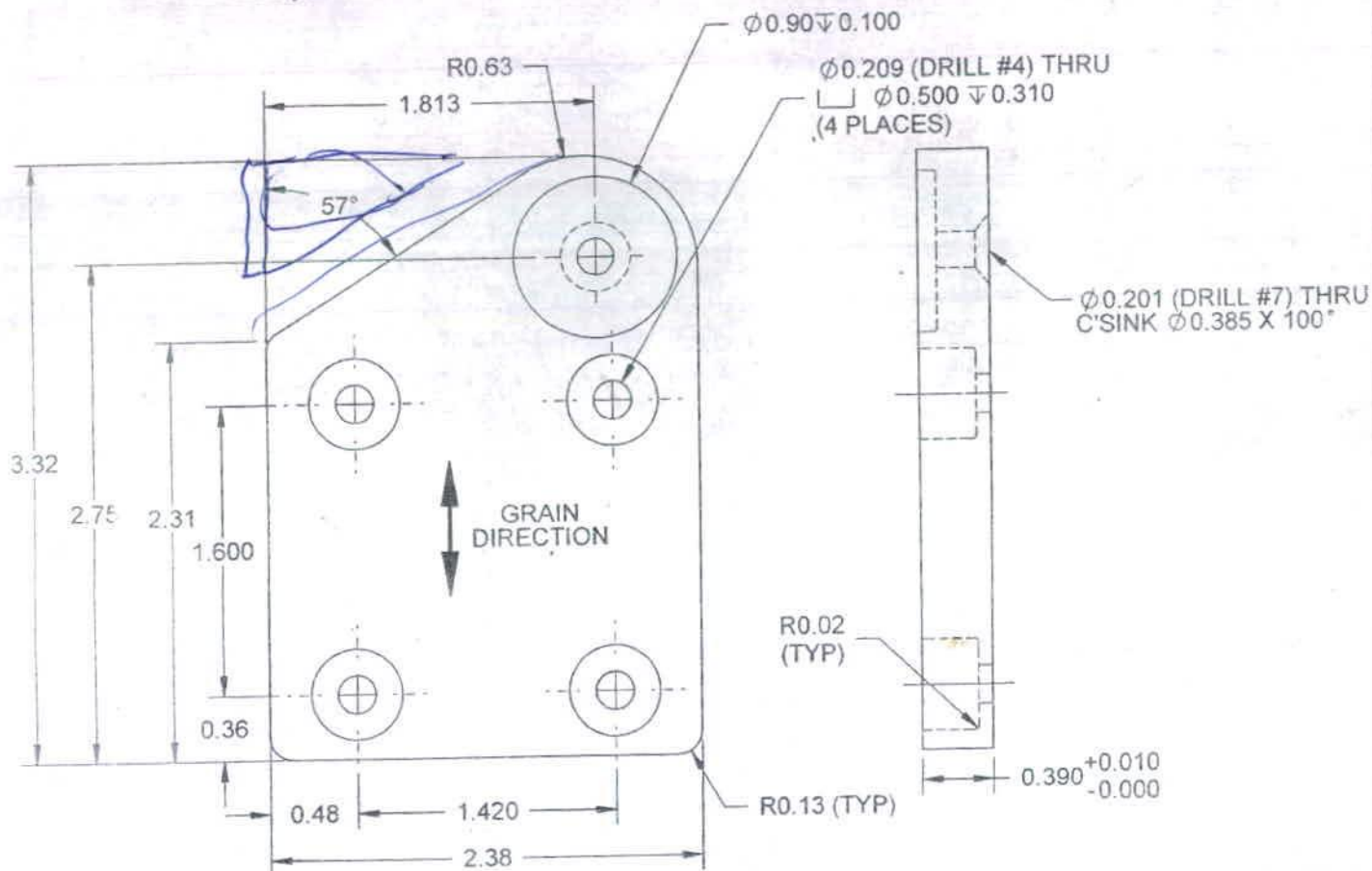
u 07-05-16

11



**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

**RELEASED**  
07.04.02

**D3573-7 ADAPTER (SHOWN)**  
**D3573-8 ADAPTER (OPPOSITE)**

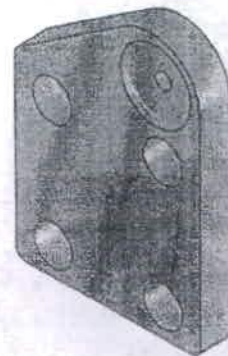
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31864

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160  
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 31864-2
Description: ADAPTER		Part Number: D3573-7
Inspection Dwg: D3573 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	± 0.030	R0.125	—			
2.38	± 0.030	2.373	—			
1.420	± 0.005	1.420	—			
0.48	± 0.030	0.478	—			
0.36	± 0.030	0.355	—			
1.600	± 0.005	1.600	—			
2.31	± 0.030	2.310	—			
2.75	± 0.030	2.750	—			
3.32	± 0.030	3.311	—			
57°	± 1/2°	57°	—			
1.813	± 0.010	1.814	—			
Ø0.90	± 0.030	Ø0.900	—			
Ø0.100	± 0.010	Ø0.101	—			
Ø0.209	± 0.005	Ø0.210	—			
Ø0.500	± 0.010	Ø0.500	—			
0.310	± 0.010	0.310	—			
Ø0.201	± 0.005	Ø0.202	—			
Ø0.385x100°	± 0.010	Ø0.385x100°	—			
0.396	± 0.010	0.394	—			

Measured by: <i>JMK</i>	Audited by: <i>J.L</i>	Prototype Approval:
Date: 07/05/12	Date: 07/05/14	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

